

SPLIT

Date: Thursday, 10/19/2006 2:50:34 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT BRACKET  
Job Number : 29078  
Estimate Number : 11856  
P.O. Number : N/A  
This Issue : 10/19/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : MACHINED PARTS  
Previous Run : N/A  
Written By :  
Checked & Approved By :  
Comment : Est: D 09:04:24 Removed P/O from powder coat EC

Part Number : D23625  
Drawing Number : D2362 REV E  
Project Number : N/A  
Drawing Revision : E  
Material : N/A  
Due Date : 10/27/2006 Qty: 6 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2265 Step Support Casting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	25401

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Machine per folio D2362-5  
Deburr

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: Inspect Level 2

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2362-5 PAR #: N/A Fault Category: Prod/machined parts NCR: Yes No DQA: JD Date: 06/10/27  
 QA: N/C Closed: HJ Date: 06.10.30

NCR: <u>29078-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06/10/20</u>	<u>2.0</u>	<u>.257x.750 slot was elongated to 1" by Set-up error. Employee didn't subtract the tool diameter.</u>	<u>[Signature]</u>	<u>1" slot acceptable on this part only.</u>	<u>J.L.</u> <u>06/10/20</u>	<u>[Signature]</u> <u>06.10.20</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>06/10/20</u>
<u>06/10/20</u>	<u>2.0</u>	<u>.257x.750 slot was put in the wrong spot on the part. Programmed Human error.</u>	<u>[Signature]</u>	<u>Part scrapped; slot program fixed, Destroy Part</u>	<u>J.L.</u> <u>06/10/20</u>	<u>[Signature]</u> <u>06.10.20</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>06/10.20</u>
			<u>2</u>				<u>[Signature]</u>	

NOTE: Date & initial all entries



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Drawing Name: SUPPORT BRACKET

Job Number: 29078

Part Number: D23625

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

LB 06/10/26 (2)

7.0

D23975

Rubber Cushions



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-5

Rubber

B13372

LB 06/10/26 (2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-5 using contact cementas per Dwg D2362

MF. 06/10/26 (2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/10/27 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57172

LB 06/10/27 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

LB 06/10/27

Job Completion



u 2010.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART****RELEASED**  
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
BW	APPROVED <i>CP</i>	DRAWING NO. D2362	SHEET 1 OF 3
CHECKED <i>KE</i>	DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

**UNDER REVIEW**

12/03/95 CP

DESIGN OK, BUT CHECK WITH  
DIB BEFORE MANUFACTURE

OK if photo of

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 29078

D2362-3REMOVE TIPS  
FROM CASTING  
MAX 0.080CENTER D2397-1/-3 RUBBER  
HOLE WITH SLOT AND BOND  
WITH CONTACT CEMENT PER  
MANUFACTURER'S SPECIFICATIOND2397-1 RUBBER CUSHION (1)  
D2397-3 RUBBER CUSHION (1)

VIEW A-A

0.257 X 0.75 SLOT

0.80

0.800

1.000

1.28

1.275

1.200

Ø0.257

1.500

0.77

0.767

3.074

0.339

0.34

**NOTES:**

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING

RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED CP	DRAWING NO. D2362	SHEET 2 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET		SCALE 1:2

**RELEASED**  
98.12.14 KE  
**UNDER REVIEW**

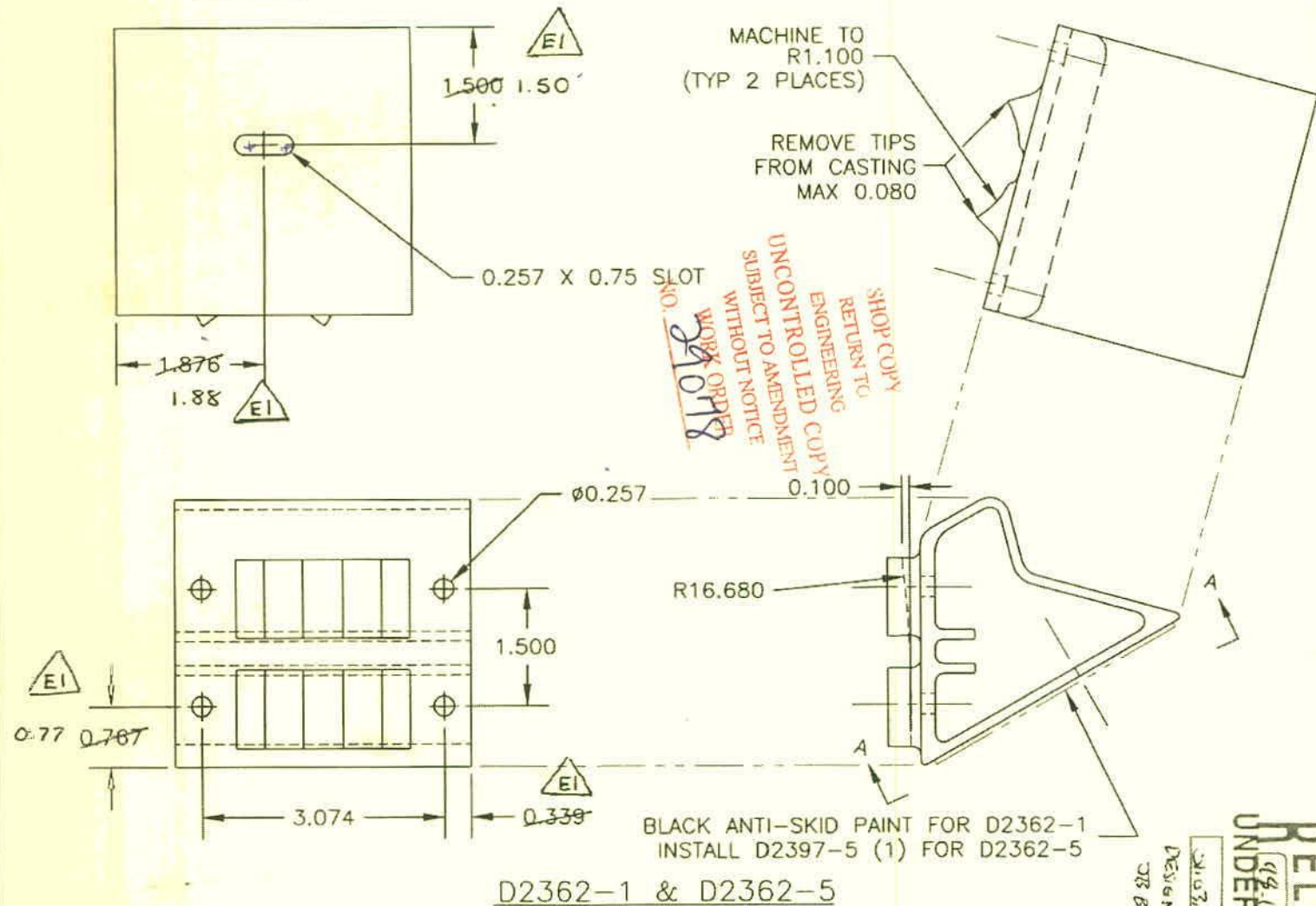
DESIGN OK, BUT CHECK BY  
DB BEFORE MANUFACTURE  
OK 1/24/04

MACHINE TO  
R1.100  
(TYP 2 PLACES)

REMOVE TIPS  
FROM CASTING  
MAX 0.080

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WITHOUT NOTICE  
NO. 24018  
WORK ORDER

VIEW A-A



BLACK ANTI-SKID PAINT FOR D2362-1  
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

**NOTES:**

- MAKE FROM D2265
- D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION
- FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	MA	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 3 OF 3
		SCALE
		1:2

UNDER REVIEW

01.03.15 CP

DESIGN OK BUT CHECK WITH  
DTS BEFORE MANUFACTURE

RELEASED  
98.12.14 KE

D2362-D41 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED

REMOVE TIPS  
FROM CASTING  
MAX 0.080

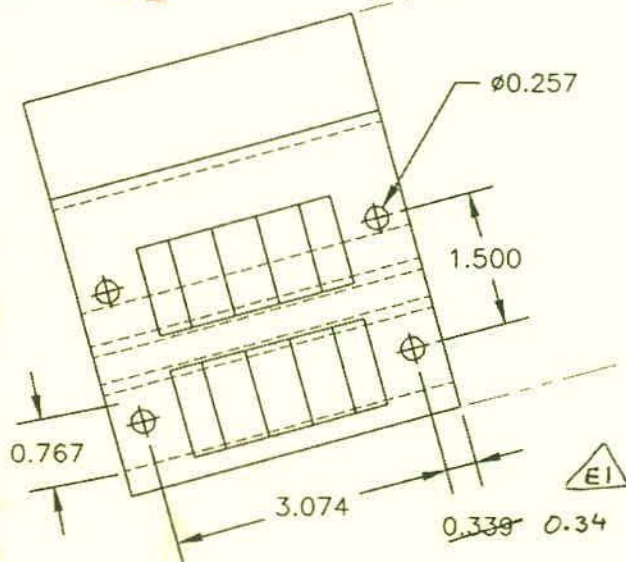
BLACK ANTI-SKID PAINT

D2244-3.75

WELD PER DART 1/8  
QSI 004

D2362-7

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39078









3.745